

Ship June 30

Dart Aerospace Ltd.

Date: Monday, 6/12/2006 3:49:07 PM  
User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : STRUT WELDMENT ASS'Y  
Job Number : 27531  
Estimate Number : 10566  
P.O. Number : N/A Part Number : D34435  
This Issue : 6/12/2006 S.O. No. : N/A Drawing Number : D3443 REV.B  
Prsht Rev. : NC Project Number : N/A  
First Issue : N/A Type : SMALL /MED FAB Drawing Revision : B  
Previous Run : 25520 Material : N/A  
Written By : See Attachment Below Due Date : 6/19/2006 Qty: 4 Um: Each  
Checked & Approved By : FF 06.06.13N  
Comment : A 05.11.14 New issue EC

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304TR0750W120 Inventory



Comment: Qty.: 0.5198 f(s)/Unit Total: 2.0790 f(s)  
Inventory  
AISI 304 SS seamless tubing .750 OD x 0.120 wall  
(M304TR0750W120)  
Batch: M18457

FF 06.06.21

FF 06.06.16

2.0 BAND SAW BAND SAW



Comment: BAND SAW  
Cut blank 5.97' long

FF 06.06.21

FF 06.06.16

3.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE  
1- Mill to length and drill holes as per dwg D3443  
2-Deburr as per dwg D3443

FF 06.06.21

FF 06.06.16

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

FF 06.06.21

FF 06.06.16

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

J.G. 06/06/20 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR: 27531		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06/06/21	1.0	4 parts scrap. Parts were cut to <del>length</del> to length and should have been mach as instructed by milling.	<i>AB</i> <i>06/06/21</i>	Scrap: replace parts.	<i>06/06/21</i> <i>JB</i>	<i>06/06/26</i> <i>JB</i>	<i>06/06/21</i> <i>JB</i>	<i>06/06/21</i> <i>JB</i>

Part No: D3443-5 PAR #: N/A Fault Category: Prod / Mfg NCR: Yes No DQA: Yes Date: 06/06/23  
 NOTE: Date & initial all entries QA: N/C Closed: Yes Date: 06.06.25

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT WELDMENT ASS'Y

Job Number: 27531

Part Number: D34435

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST437

*1*

*SL 06/06/22 (4)*

7.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

*SD 06/06/23 (4)*

Job Completion



*U 06-06-23*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

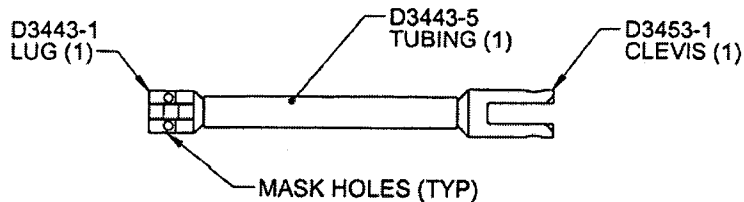
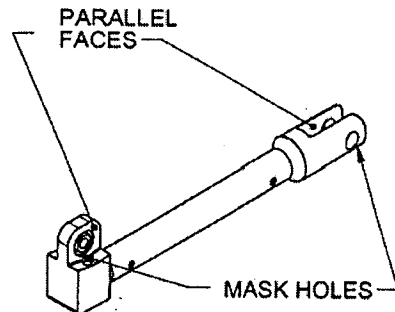
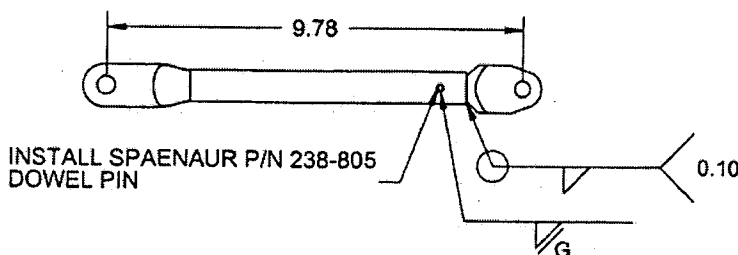
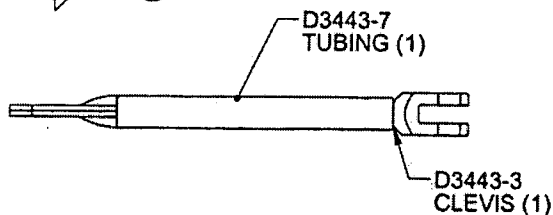
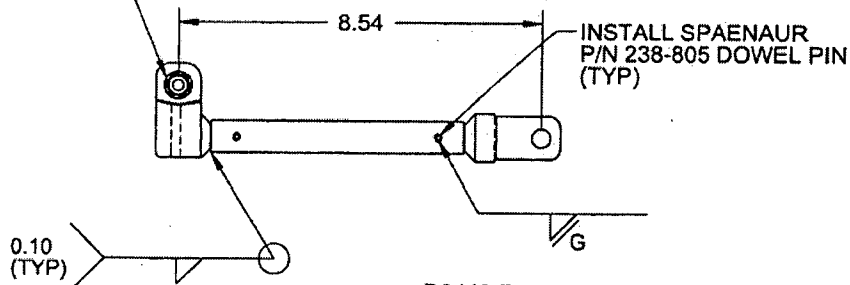
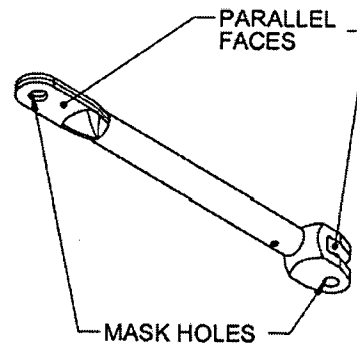
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

**DART**

DESIGN RF	DRAWN BY RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. <b>D3443</b>	REV. B SHEET 1 OF 3
DATE <b>05.12.05</b>	TITLE <b>STRUT WELDMENT ASSEMBLY</b> SCALE 1:4		
A	05.09.02	NEW ISSUE	
B	05.12.05	ADDED -9 PIN; REMOVED BALL PLUNGER; REVISE TOLERANCE; & Ø0.125 WAS #30	



**RELEASED**05.12.09 *H*PRESS FIT McMASTER-CARR P/N 63215K32  
BALL JOINT BEARING AFTER POWDER COAT**D3443-041****D3443-043****NOTES:**

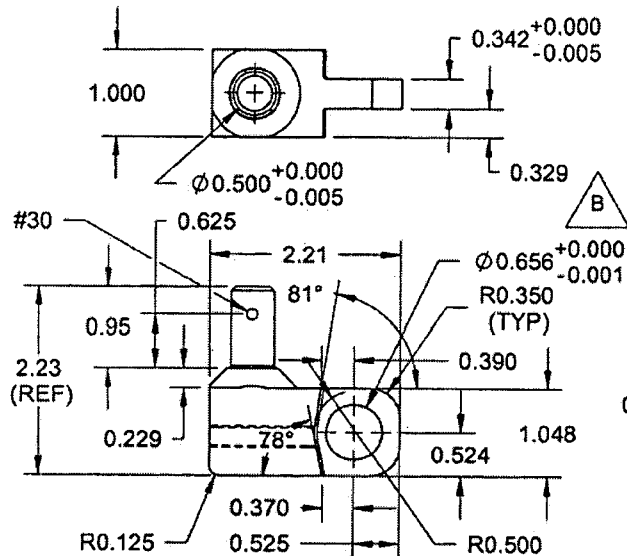
- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

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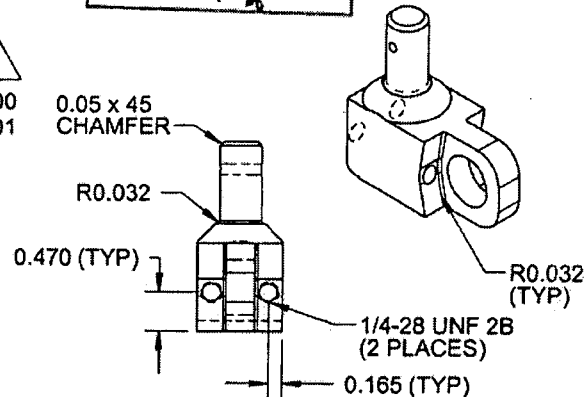
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DATE <b>05.12.05</b>		TITLE <b>STRUT WELDMENT ASSEMBLY</b> SCALE 1:2	



**RELEASED**

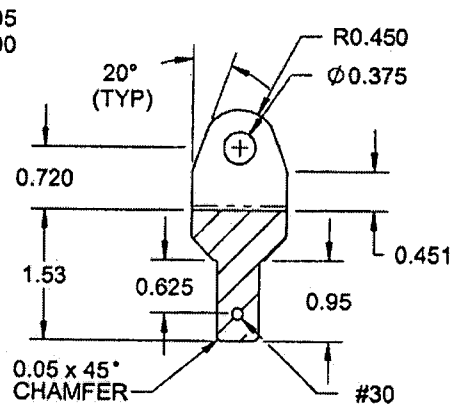
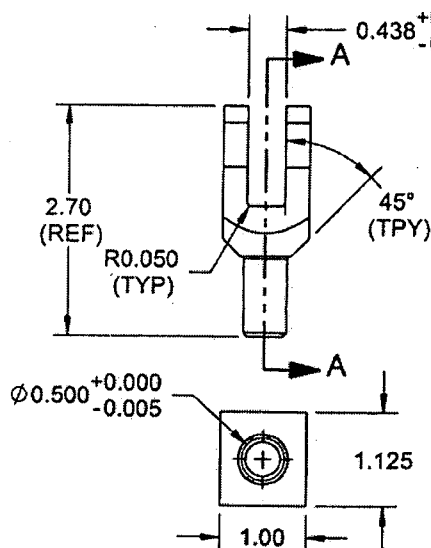
05.12.09



**D3443-1 LUG**

**D3443-1 NOTES:**

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC M17-4B)



**SECTION A-A**

**D3443-3 CLEVIS**

**D3443-3 NOTES:**

- 1) MATERIAL: AISI 304 SS ROUND BAR (REF. DART SPEC M304R)

**GENERAL NOTES:**

- 2) FINISH: NONE  
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) ALL DIMENSIONS ARE IN INCHES  
5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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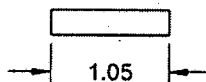
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CHECKED #	APPROVED #	DRAWING NO. D3443	REV. B SHEET 3 OF 3
DATE 05.12.05		TITLE STRUT WELDMENT ASSEMBLY	SCALE 1:2

$\phi 0.210^{+0.005}_{-0.010}$



**D3443-9 PIN**

**D3443-9 NOTES:**

- 1) MATERIAL: DELRIN II 150R OR ACETRON GP ACETAIL (REF. DART SPEC M-DELRIN-R)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

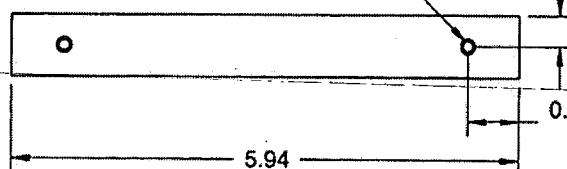
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05.12.05

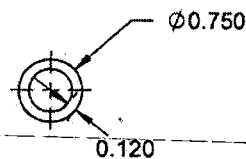


DRILL  $\phi 0.125$  THRU  
CHAMFER 0.025 (TYP)

0.375

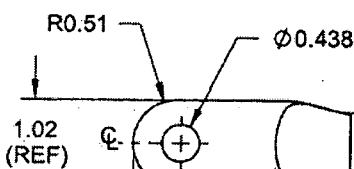
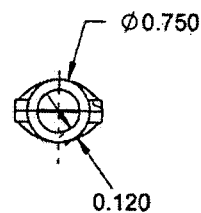
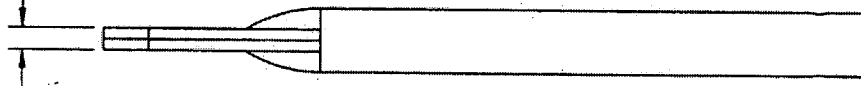


$0.610^{+0.015}_{-0.000}$   
(TYP)



**D3443-5 TUBING**

$0.260^{+0.000}_{-0.030}$



DRILL  $\phi 0.125$  THRU  
CHAMFER 0.025

0.375

0.55 1.10 FLATTEN END

8.47

$0.610^{+0.015}_{-0.000}$

**D3443-7 TUBING**

**D3443-5/-7 NOTES:**

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC M304TR0.7500W120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.025

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